

บริษัท น้ำมันอพอลโล [ไทย] จำกัด APOLLO (THAILAND) CO.,LTD.



DAPHNE PLASTIC QUENCH HF

1. Application

Daphne Plastic Quench HF is a water-soluble quenching oil used for induction hardening.

2. Characteristics

- 1. Superior crack ability prevention because of its relatively small quenching speed below 250 °C.
- 2. Superior anti-bacteria property shows less deterioration especially at summer period.

3. Typical Specification

Soluble Concentration		<u>Undiluted</u> Solution	<u>5%</u>	<u>10%</u>	<u>20%</u>	
Viscosity	@ 40 °C	cSt	29.5	0.873	1.129	1.809
Refractive Index	N_D^{20}		1.3714	1.3348	1.3369	1.3406
рН			10.2	9.3	9.4	9.8

4. Properly Using

- 1. Optimum temperature is 30-40°C if heat up over 65°C polymer component will be separated.
- 2. Selection of Soluble concentration according to quenching speed and use handrefractrometer to measure concentration.
- 3. Incase of using at high concentration, polymer compounds possible adhere on surface of material, it should be washed by hot water.

5.Concentrate Application

High Frequency Hardening					
(1) Carbon Steel	Rear Axle Shaft	5% Gear	Туре	5~8%)
	Clank Shaft	5%			
	Cam Shaft	5%			
(2)Low Alloy Construction Steel	Rear Axle Shaft	5~10%	Gear	Туре	8~10%
(3)Maine Blue Cast Iron	Boil Hub	8~10%			

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้นิคมอุตสาหกรรมอมตะนคร 700/623 หมู่ที่ 4 ต..บ้านเก่า อ.พานทอง จ. ชลบุรี 20160 โทร. 038-456-900 แฟกซ์ 038-210-055

Amatanakorn Industrial Estate 700/623 Moo 4, Bankao, Panthong, Chonburi 20160 Tel : 038-456-900 Fax : 038-210-055 www.apollothai.com